

304 R 0.375"

Work Order ID 76190

76190

Page 1

November-07-11 1:26:53 PM

Item ID: D2829

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Threaded Stud

Start Date: 07/11/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/08

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2829

Rev B

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

36
404
0

11/12/27

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

36
404
0

11/12/27

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

D.A 12/01/05

36

4

W/O: 7690

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2829 PAR #: _____ Fault Category: Machining NCR: Yes ☒ No ☐ DQA: OK Date: 12/1/11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/1/11

NCR: 11-1105

WORK ORDER NON-CONFORMANCE (NCR) 12.84

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/27	100	insert broke during machining on 4 of them RC: PROCESS	S 12/1/105 Q57-0047	Scrap + Destroy no reply.	12/1/27	S 12/1/105	Q57-0047 12/1/105	S 12/1/105

NOTE: Date & initial all entries

Work Order ID 76190

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November-07-11 1:26:53 PM

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N900040100

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40

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 40.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>EA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/1/19 *[Signature]*

ME
12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-07-11 1:26:58 PM

Page 1

Work Order ID: 76190

76190

Parent Item: D2829

D2829

Parent Item Name: Threaded Stud

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A99.07.13New IssueDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R0.375

Purchased

No

110

f

41.9780

0.1

4.210526

M304R0 375

304 ROUND BAR 0.375

**

4.463'

11/12/27

Location

Loc Qty

Loc Code

MAT029

41.978

117130

2.46

118449

0.018

119346

39.5

4.463'

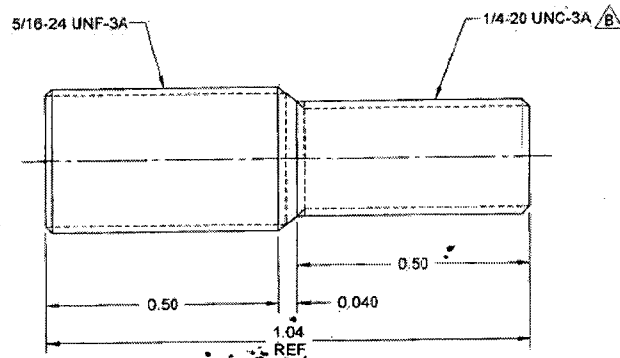
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2829 THREADED STUD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76190

2011-07

RELEASED
06/10/27

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. D304RD.DDD
OR
AISI 303 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M303RD.DDD
- 2) FINISH: NONE
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

B	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; MATERIAL WAS AISI 4130 (ZIN AB-1); 1/4-20 UNC-3A WAS 1/4-20 UNF-3A (ZIN CE-1); REASON: REVISION OF D2011 FROM REV. F TO REV. G	MB	08.10.03
A	NEW ISSUE	RF	09.05.31
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2829** REV. B
SHEET 1 OF 1

TITLE **THREADED STUD** SCALE
NTS

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